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008381

**D4634-141**  
**Job Sheet 185830**



**Part No:** D4634-141

**Job Qty:** 1 pcs

**Part Name:** Fwd, Center Ceiling Replacement Panel Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 11/2/18

**Job Tracking No:**

**Due Date:** 12/7/18

**Created By:** Jesse White

**Type:** Stock

**Description:**

**Note:** DWG D4634 REV G SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                 | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                |
|-------|---------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------------------|
|       |                           |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                         |
| 100   | Handfinish - 4 - Assembly | 1 pcs | 12/7/18    | 12/7/18  | 0.00      | 1.65    | Handfinish - 4 - 1    |           | DAS 58 9-89 MAR 12 2019 |
|       |                           |       |            |          |           |         | Handfinish - 4 - 10   |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 11   |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 12   |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 13   |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 14   |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 15   |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 2    |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 3    |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 4    |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 5    |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 6    |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 7    |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 8    |           |                         |
|       |                           |       |            |          |           |         | Handfinish - 4 - 9    |           |                         |
| 110   | Small Fab - 2 - B4B       | 1 pcs | 12/7/18    | 12/7/18  | 0.00      | 1.47    | Small Fab - 1 - B4B   |           | DAS 58 9-89 MAR 12 2019 |
|       |                           |       |            |          |           |         | Small Fab - 2 - B4B   |           |                         |
|       |                           |       |            |          |           |         | Small Fab - 3 - B4B   |           |                         |
|       |                           |       |            |          |           |         | Small Fab - 4 - B4B   |           |                         |
|       |                           |       |            |          |           |         | Small Fab - 5 - B4B   |           |                         |
|       |                           |       |            |          |           |         | Small Fab - 6 - B4B   |           |                         |
|       |                           |       |            |          |           |         | Small Fab - 7 - B4B   |           |                         |
| 120   | QC 5                      | 1 pcs | 12/7/18    | 12/7/18  | 0.00      | 0.00    | QC 5 - 10             |           |                         |
|       |                           |       |            |          |           |         | QC 5 - 12             |           |                         |
|       |                           |       |            |          |           |         | QC 5 - 17             |           |                         |
|       |                           |       |            |          |           |         | QC 5 - 18             |           |                         |
|       |                           |       |            |          |           |         | QC 5 - 19             |           |                         |
|       |                           |       |            |          |           |         | QC 5 - 22             |           |                         |
|       |                           |       |            |          |           |         | QC 5 - 24             |           |                         |
|       |                           |       |            |          |           |         | QC 5 - 3              |           |                         |

|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           |                        |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-------|---------|-----------|------------------------|
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 38 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 42 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 43 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 49 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 51 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 58 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 68 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 9  | PD 19.03.13            |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 50 |                        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         | QC 5 - 30 |                        |
| 130                                                                                                                                                                                                                                                                                                                                                       | Packaging 3-1 - Stock - B4B | 1 pcs | 12/7/18 | 0.00 0.00 | Packaging 3 - 1 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 2 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 3 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 4 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 5 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 6 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 7 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 8 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 9 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 10 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 11 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 12 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 13 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 14 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 15 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 16 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 17 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 18 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 19 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 20 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 21 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 22 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 23 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 24 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 25 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 26 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 27 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 28 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 29 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 30 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 31 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 32 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 33 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 34 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 35 - B4B |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | Packaging 3 - 36 - B4B |
| 140                                                                                                                                                                                                                                                                                                                                                       | QC 21 - SA                  | 1 pcs | 12/7/18 | 0.00 0.00 | QC 21 - SA - 21        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | QC 21 - SA - 70        |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | MAR 13 2019            |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | DAS 70                 |
|                                                                                                                                                                                                                                                                                                                                                           |                             |       |         |           | 9-89                   |
| Part Op 100 - HandFinish4 (Assemble as per dwg)                                                                                                                                                                                                                                                                                                           |                             |       |         |           |                        |
| Descriptions: 110 - Small Fab (Small Fab) Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300                                                                                                                                                                                                                             |                             |       |         |           |                        |
| Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____ |                             |       |         |           |                        |
| 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O                                                                                                                                                                                                                                                   |                             |       |         |           |                        |
| 130 - Packaging3 (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____                                                                                                                                                                                                                                                |                             |       |         |           |                        |
| 140 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release                                                                                                                                                                                                                                                      |                             |       |         |           |                        |

# Job BOM

| Part / Item   | Component Name            | Quantity     | Operation                     | Container   |
|---------------|---------------------------|--------------|-------------------------------|-------------|
| D4634-1       | Fwd, Center Ceiling Panel | 1 Ea (1 ea)  | 100-Handfinish - 4 - Assembly | 5131079     |
| D4636-5       | Bracket                   | 1 pcs (1 ea) | 100-Handfinish - 4 - Assembly | 5122035     |
| D4647-5       | Doubler                   | 1 pcs (1 ea) | 100-Handfinish - 4 - Assembly | 5122162     |
| D4664-5       | Spacer                    | 6 pcs (6 ea) | 100-Handfinish - 4 - Assembly | 5132202     |
| D4712-1       | Bracket                   | 1 pcs (1 ea) | 100-Handfinish - 4 - Assembly | 5008996     |
| D4732-15      | Label                     | 1 pcs (1 ea) | 100-Handfinish - 4 - Assembly | 5104125     |
| D4732-19      | Label                     | 1 pcs (1 ea) | 100-Handfinish - 4 - Assembly | 5008993     |
| D5021-1       | Foam, Center Panel, Fwd   | 1 pcs (1 ea) | 100-Handfinish - 4 - Assembly | 5133618     |
| MPNY-750S-9-C | Mounting Pad              | 7 pcs (7 ea) | 100-Handfinish - 4 - Assembly | fm130123-1  |
| MS20426AD3-4  | Rivet                     | 4 Ea (4 ea)  | 100-Handfinish - 4 - Assembly | fm1304144-1 |
| MS20426AD4-6  | Rivet                     | 2 Ea (2 ea)  | 100-Handfinish - 4 - Assembly | 50930881    |
| MS21059L08    | Nut                       | 2 Ea (2 ea)  | 100-Handfinish - 4 - Assembly | 5016505     |
| CCR26455-3.04 |                           | x4           |                               | 5033756     |

# Job Allocations

| Operation                     | Component Part | Required | Inventory | Allocated |
|-------------------------------|----------------|----------|-----------|-----------|
| 100-Handfinish - 4 - Assembly | D4634-1        | 1        | 4         | 0         |
|                               | D4636-5        | 1        | 63        | 0         |
|                               | D4647-5        | 1        | 16        | 0         |
|                               | D4664-5        | 6        | 43        | 0         |
|                               | D4712-1        | 1        | 8         | 0         |
|                               | D4732-15       | 1        | 10        | 0         |
|                               | D4732-19       | 1        | 13        | 0         |
|                               | D5021-1        | 1        | 2         | 0         |
|                               | MPNY-750S-9-C  | 7        | 152       | 0         |
|                               | MS20426AD3-4   | 4        | 3,547     | 0         |
|                               | MS20426AD4-6   | 2        | 1,387     | 0         |
|                               | MS21059L08     | 2        | 171       | 0         |

# Part Specifications

Specifications could not be found.

fg234  
mfoos  
mfo04  
mfo04  
mfo04  
mfo05  
mfoos  
fg236  
ST510  
GA006  
G9007  
ST300

Replace MS  
For CCR  
1/19/03.12  
Check at back  
For Route Update

5132125





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**D4634-141**  
**Job Sheet 185830**



**Part No:** D4634-141

**Job Qty:** 1 ea

**Part Name:** Fwd, Center Ceiling Replacement Panel Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 11/2/18

**Job Tracking No:**

**Due Date:** 12/7/18

**Created By:** Jesse White

**Type:** Stock

**Description:**

**Note:** DWG D4634 REV G SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 1 Ea  |            | 12/7/18  | 0.00      | 0.00    | Start Up Small Fab    |           |          |
| 100   | HandThermo         | 1 pcs |            | 12/7/18  | 0.00      | 1.65    | HandFinish4           |           |          |
| 110   | Small Fab          | 1 pcs |            | 12/7/18  | 0.00      | 1.47    | Small Fab             |           |          |
| 120   | QC                 | 1 pcs |            | 12/7/18  | 0.00      | 0.00    | QC5                   |           |          |
| 130   | Packaging          | 1 pcs |            | 12/7/18  | 0.00      | 0.00    | Packaging3            |           |          |
| 140   | QC21-SA            | 1 Ea  |            | 12/7/18  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: \_\_\_\_\_ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # \_\_\_\_\_ Expiry Date \_\_\_\_\_ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: \_\_\_\_\_  
120 - QC5- Inspect part completeness to step on W/O  
130 - Identify as per dwg & Stock Location: \_\_\_\_\_  
140 - QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item   | Component Name            | Quantity     | Operation             | Container |
|---------------|---------------------------|--------------|-----------------------|-----------|
| D4634-1       | Fwd, Center Ceiling Panel | 1 Ea (1 ea)  | 90-Start up Operation |           |
| D4636-5       | Bracket                   | 1 Ea (1 ea)  | 90-Start up Operation |           |
| D4647-5       | Doubler                   | 1 Ea (1 ea)  | 90-Start up Operation |           |
| D4664-5       | Spacer                    | 6 Ea (6 ea)  | 90-Start up Operation |           |
| D4712-1       | Bracket                   | 1 Ea (1 ea)  | 90-Start up Operation |           |
| D4732-15      | Label                     | 1 Ea (1 ea)  | 90-Start up Operation |           |
| D4732-19      | Label                     | 1 Ea (1 ea)  | 90-Start up Operation |           |
| D5021-1       | Foam, Center Panel, Fwd   | 1 Ea (1 ea)  | 90-Start up Operation |           |
| MPNY-750S-9-C | Mounting Pad              | 7 pcs (7 ea) | 90-Start up Operation |           |
| MS20426AD3-4  | Rivet                     | 4 Ea (4 ea)  | 90-Start up Operation |           |
| MS20426AD4-6  | Rivet                     | 2 Ea (2 ea)  | 90-Start up Operation |           |
| MS21059L08    | Nut                       | 2 Ea (2 ea)  | 90-Start up Operation |           |

**Job Allocations**

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D4634-1        | 1        | 1         | 0         |
|                       | D4636-5        | 1        | 79        | 0         |
|                       | D4647-5        | 1        | 3         | 0         |
|                       | D4664-5        | 6        | 21        | 0         |
|                       | D4712-1        | 1        | 17        | 0         |
|                       | D4732-15       | 1        | 12        | 0         |
|                       | D4732-19       | 1        | 15        | 0         |
|                       | D5021-1        | 1        | 4         | 0         |
|                       | MPNY-750S-9-C  | 7        | 126       | 0         |
|                       | MS20426AD3-4   | 4        | 4,578     | 0         |
|                       | MS20426AD4-6   | 2        | 1,909     | 0         |
|                       | MS21059L08     | 2        | 134       | 0         |

**Part Specifications**

Specifications could not be found.

Plex 11/2/18 4:07 PM dart.white.jesse



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**Container No: S161548**



**Part: D4634-141**

**Job No: 185830**

**Serial No/Batch: S161548**

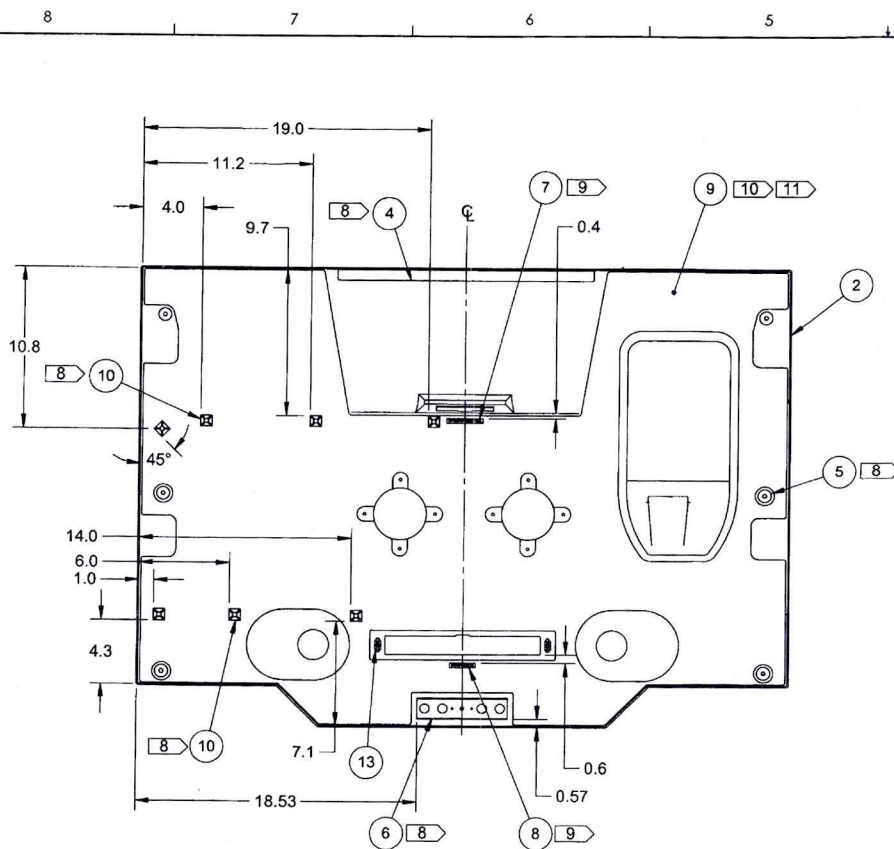
**Revision: G**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Date: 03/12/19**

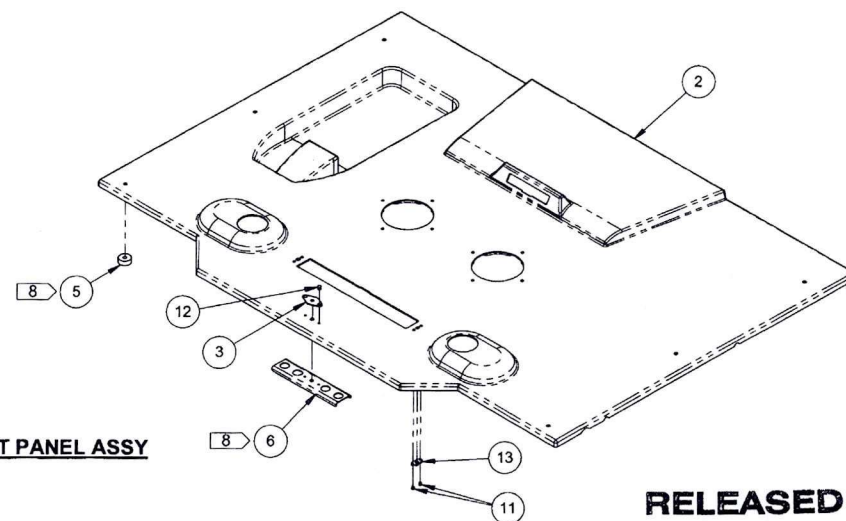


**D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4664-5, D4712-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-1 FOAM ON D4634-1

| ITEM | QTY<br>-141 | P/N            | DESCRIPTION                                |
|------|-------------|----------------|--------------------------------------------|
| 1    | X           | D4634-141      | FWD, CENTER CEILING REPLACEMENT PANEL ASSY |
| 2    | 1           | D4634-1        | FWD, CENTER CEILING PANEL                  |
| 3    | 1           | D4636-5        | BRACKET                                    |
| 4    | 1           | D4647-5        | DOUBLER                                    |
| 5    | 6           | D4664-5        | SPACER                                     |
| 6    | 1           | D4712-1        | BRACKET                                    |
| 7    | 1           | D4732-15       | LABEL                                      |
| 8    | 1           | D4732-19       | LABEL                                      |
| 9    | 1           | D5021-1        | FOAM, CENTER PANEL, FWD                    |
| 10   | 7           | MPNY-750S-9-C  | MOUNTING PAD                               |
| 11   | 4           | MS20426AD3-(4) | RIVET, SOLID, CSK                          |
| 12   | 2           | MS20426AD4-(6) | RIVET, SOLID, CSK                          |
| 13   | 2           | MS21059L08     | NUT PLATE                                  |



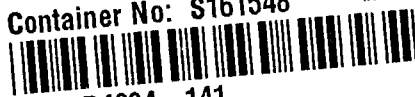
**RELEASED**  
2015 JAN 26 *qp*

APPROVED

|            |          |                                                                                                                                                                                                                                                                          |               |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                 |               |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                          |               |
| CHECKED    | AK       | DRAWING NO.                                                                                                                                                                                                                                                              | REV. G        |
| MFG. APPR. | DL       | <b>D4634</b>                                                                                                                                                                                                                                                             | SHEET 7 OF 17 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                    | SCALE         |
| DE APPR.   | DS       | <b>CENTER CEILING PANELS</b>                                                                                                                                                                                                                                             | NTS           |
| DATE       | 14.11.28 | COPYRIGHT © 2012 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |               |



Container No: S161548



Part: D4634-141

Job No: 185830

Serial No/Batch: S161548

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

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Email: sales@dartaero.com  
www.dartaerospace.com

Date: 03/12/19



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                                                                       |
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| Job: _____<br><br>Part No. <u>D4634-141</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <b>DISPOSITION</b><br><br>Rework <input checked="" type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |  |                                                                       |
| Date : <u>12/3/12</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Sequence #:                                                                                                                                  | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | MRB (QSI042)<br><br><u>INSP 12</u> <u>UP 12/3/12</u>                  |
| <b>Description Work Order Deviation</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                              | <b>Disposition</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                       |
| <u>MS20426 AD3-144 Rivet are difficult to install. Part geometry doesn't allow easy use of rivet tool for solid rivets.</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                              | <u>Acceptable to use CLR26455-3-04 Nut plate rivets. Rivets are for securing nutplate only and are not under load.</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | Completed By<br><br>Lead hand / Supervisor<br><br>QC / QA Coordinator |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                              | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                                                                       |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                                                                       |